

Date: Wednesday, 03/09/2008 8:52:06 AM
User: Julie Lecocq





Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SADDLE FITTING, AFT (OUTBOARD/INBOARD)
Job Number :	41706	Part Number :	D2574
Estimate Number :	10534	Drawing Number :	D2574 REV E
P.O. Number :		Project Number :	N/A
This Issue :	03/09/2008	Drawing Revision :	E
Prsht Rev. :	NC	Material :	
First Issue :	//	Due Date :	30/09/2008
Previous Run :	41590	Qty:	10
Written By :		Um:	Each
Checked & Approved By :	<u>JUD 08.9.03</u>		
Comment :	Est Rev: I As Per RevE 06-01-27 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6101005	Saddle Billet
 		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) 7075-T7351 8.25X5.0X2.5 Make from D6101-005 billet for D2574 Ensure that grain is along 5.00" length Batch No: <u>B34874</u>		
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
 		
Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No. <u>41706</u> Double check by: <u>DTP</u> 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges.		
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
 		
Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2573 & D2574		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
 		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 03/09/2008 8:52:06 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 41706

Part Number: D2574

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

JI 08/09/21

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-L

08/09/22

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:45
320°F
2:15

M-L

08/09/23

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

JI

08-09-23

(X10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 433

SS

08/09/24

10

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/24 JF

Job Completion



W 08/09/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 41706	
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E	Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.7500	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.508	.508	.510	.510		
G	0.257	0.262		.259	.259	.258	.258		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.503	.503	.503	.505		
J	1.174	1.184		1.178	1.178	1.178	1.178		
K	0.558	0.578		.570	.570	.568	.568		
L	1.174	1.184		1.178	1.178	1.178	1.178		
M	1.365	1.375		1.371	1.371	1.371	1.371		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.123	4.123	4.123	4.123		
P	0.115	0.135		.135	.135	.125	.125		
Q	0.115	0.135		.125	.125	.135	.135		
R	0.240	0.260		.250	.250	.254	.254		
S	0.115	0.135		.126	.126	.126	.126		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.234	3.234		
V	0.230	0.250		.241	.241	.241	.240		
W	0.115	0.135		.125	.125	.125	.125		
X	0.307	0.312		.310	.311	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.362	.362	.363	.363		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.625	.625	.625	.625		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.500	1.520		1.510	1.511	1.510	1.511		
AF	0.115	0.135		.125	.125	.125	.125		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.250	.250	.250	.250		
AI	2.000	2.020		2.003	2.003	2.003	2.002		
AJ	0.023	0.043		.033	.033	.022	.033		
Accept/Reject									

Measured by: <i>JS</i>
Date: 05/09/17

Audited by: <i>JS</i>
Date: 08/09/21

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order: 41706
Description: Saddle, Aft Inboard	Part Number: D2574
Inspection Dwg: D2574 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				57	66	77	48		
A	0.438	0.443		.438	.438	.439	.439		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.004	8.000	8.000	8.000		
F	0.490	0.510		.510	.508	.501	.503		
G	0.257	0.262		.258	.258	.258	.259		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.500	.501	.502	.500		
J	1.174	1.184		1.178	1.178	1.178	1.179		
K	0.558	0.578		.568	.569	.571	.568		
L	1.174	1.184		1.178	1.178	1.178	1.177		
M	1.365	1.375		1.370	1.369	1.369	1.378		
N	2.495	2.505		2.500	2.500	2.499	2.500		
O	4.119	4.129		4.124	4.122	4.122	4.121		
P	0.115	0.135		.125	.127	.127	.128		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.250	.252	.253	.253		
S	0.115	0.135		.126	.126	.123	.126		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.242	.240	.240	.241		
W	0.115	0.135		.126	.130	.129	.129		
X	0.307	0.312		.310	.310	.310	.310		
Y	0.760	0.765		.760	.761	.761	.762		
Z	0.352	0.372		.362	.368	.367	.367		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.625	.626	.627	.628		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.251	.253	.252		
AE	1.500	1.520		1.510	1.510	1.510	1.510		
AF	0.115	0.135		.125	.135	.135	.135		
AG	0.240	0.280		.250	.260	.260	.260		
AH	0.240	0.260		.250	.250	.250	.252		
AI	2.000	2.020		2.004	2.004	2.004	2.002		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: <i>ST</i>
Date: <i>02/09/17</i> / <i>02/09/18</i>

Audited by: <i>JL</i>
Date: <i>08/09/21</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM <i>JA</i>	<i>JA</i>

DART AEROSPACE LTD	Work Order: 41706
Description: Saddle, Aft Inboard	Part Number: D2574
Inspection Dwg: D2574 Rev. E	Page 1 of 1

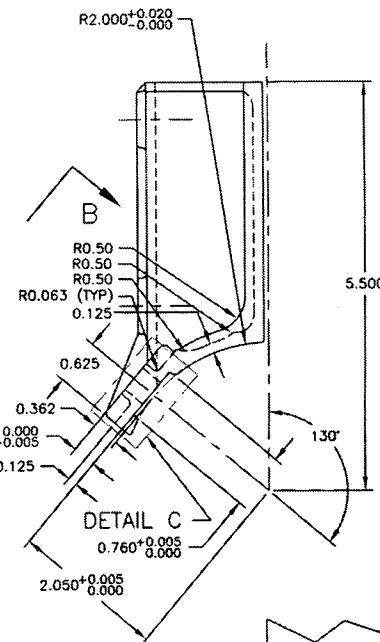
Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	19	210	3	4	By	Date
A	0.438	0.443		.438	.439				
B	1.745	1.755		1.750	1.750				
C	3.495	3.505		3.500	3.500				
D	1.745	1.755		1.750	1.750				
E	7.990	8.010		8.000	8.000				
F	0.490	0.510		.501	.505				
G	0.257	0.262		.259	.259				
H	0.375	0.380		.377	.377				
I	0.490	0.510		.499	.499				
J	1.174	1.184		1.178	1.179				
K	0.558	0.578		.568	.566				
L	1.174	1.184		1.178	1.179				
M	1.365	1.375		1.369	1.368				
N	2.495	2.505		2.499	2.499				
O	4.119	4.129		4.120	4.122				
P	0.115	0.135		.128	.128				
Q	0.115	0.135		.135	.135				
R	0.240	0.260		.252	.252				
S	0.115	0.135		.129	.127				
T	0.178	0.198		.188	.188				
U	3.210	3.250		3.236	3.236				
V	0.230	0.250		.242	.242				
W	0.115	0.135		.129	.130				
X	0.307	0.312		.310	.310				
Y	0.760	0.765		.761	.761				
Z	0.352	0.372		.367	.367				
AA	0.470	0.530		.500	.500				
AB	0.615	0.635		.629	.628				
AC	0.053	0.073		.063	.063				
AD	0.240	0.260		.254	.251				
AE	1.500	1.520		1.511	1.511				
AF	0.115	0.135		.135	.135				
AG	0.240	0.280		.265	.265				
AH	0.240	0.260		.251	.250				
AI	2.000	2.020		2.003	2.003				
AJ	0.023	0.043		.033	.033				
Accept/Reject									

Measured by: <i>Onk</i>
Date: 08/09/18

Audited by: <i>JL</i>
Date: 08/09/21

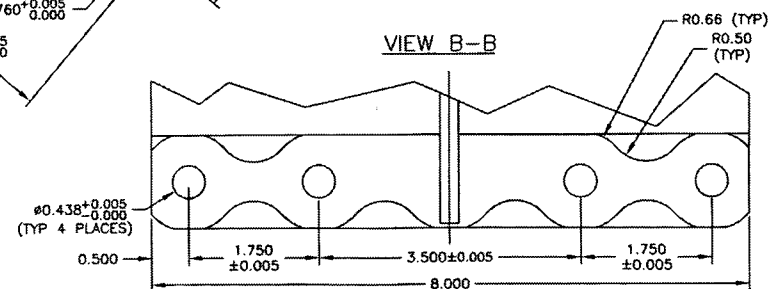
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>[Signature]</i>






05.12.06 ~~11~~

MATERIAL: 7075-T7351 (Q0-A-250/12)
(REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C)



E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4	
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES	
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177	
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425	
A	96.09.16	NEW ISSUE	
DESIGN		DRAWN BY	
DS		PH	
CHECKED 		APPROVED 	
		 DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA	
DATE		DRAWING NO.	
05.07.13		D2574	
		TITLE	
		INNER AFT SADDLE	
		SCALE	
		2:3	

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DETAIL C
SCALE 2:1

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